

Date: Monday, 6/12/2006 3:36:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB
Job Number	: 27503		Part Number	: D2739
Estimate Number	: 10498		Drawing Number	: D2739 REV C
P.O. Number	: N/A		Project Number	: N/A
This Issue	: 6/12/2006 S.O. No. : N/A		Drawing Revision	: C
Prsht Rev.	: NC		Material	: N/A
First Issue	: N/A		Due Date	: 6/30/2006
Previous Run	: 27363		Qty:	4
Written By	: <i>See Comment Below</i>		Um:	Each
Checked & Approved By	: <i>See 060613</i>			
Comment	: Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin <i>1-Cut D2600-5 to length as per Dwg D2739.</i>
		<i>Pm 06-07-10(4)</i>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 <i>2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739.</i>
		<i>Pm 06-07-11(4)</i>
		<i>3-Use uni-bit to open holes to finish size as per Dwg D2739.</i>
		<i>Pm 06-07-11(4)</i>
		<i>4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.</i>
		<i>Pm 06-07-11(4)</i>
		<i>5-Dburr</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP <i>DP 6-2-13</i>
		<i>(4)</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

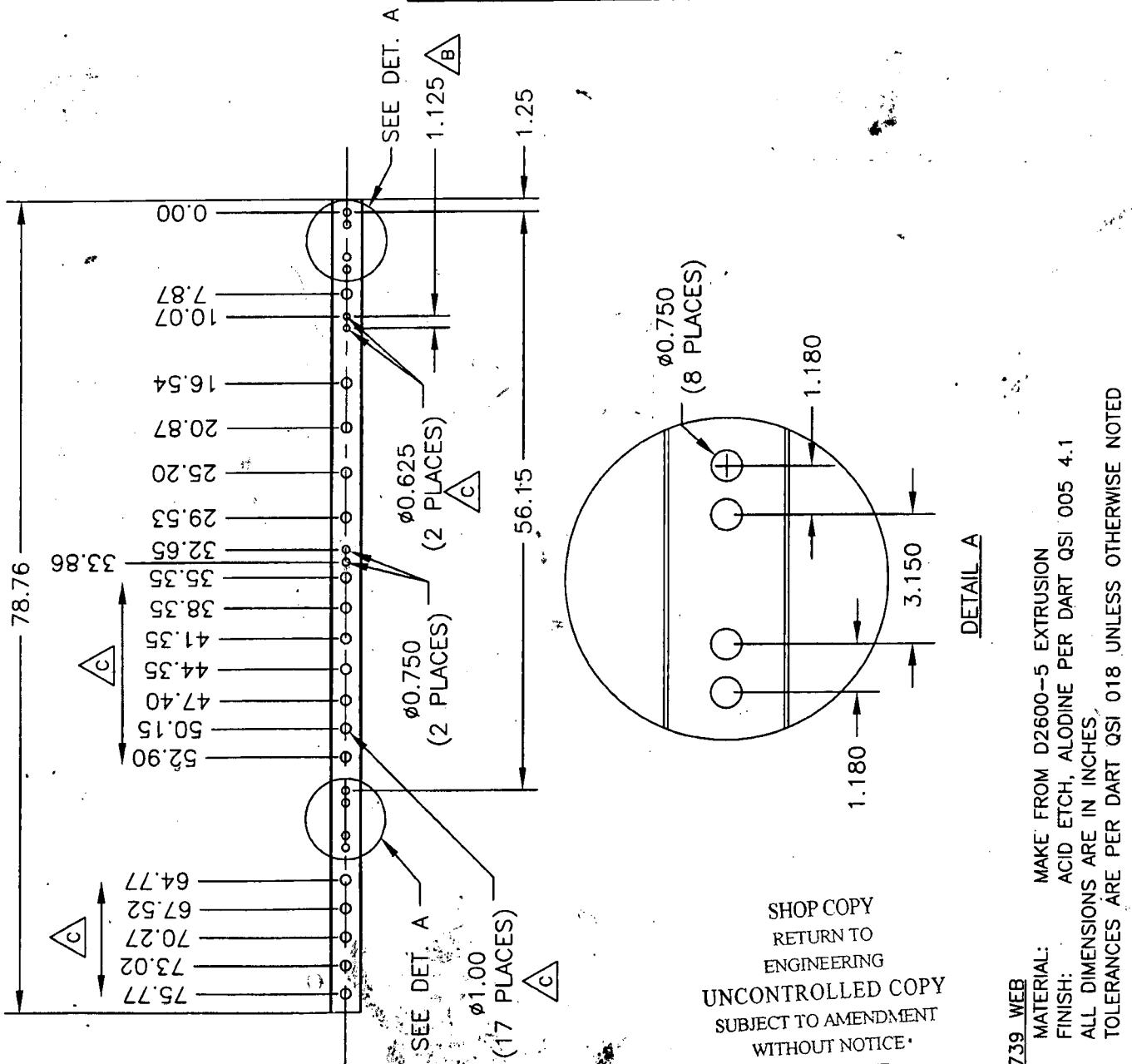
QA: N/C Closed: _____

Date: _____

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	

RELEASED
06-02-57



SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE.
WORK ORDER
NO. 27503

D2739 WEB
1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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